Work Order ID 60303

Thursday, July 01, 2010 1:09:42 PM

Item ID: D4132-3 **Accept** **Setup Start**

Revision ID: **Stop**

Item Name: Gasket

Start Date: 7/1/2010 **Start Qty:** 4.00 **Cust Item ID:**

Required Date: 7/8/2010 **Req'd Qty:** 4.00 **Customer:**

Reference:

Approvals: **Process Plan:** [signature] **Date:** 6-7-01 **Tooling:** _____ **Date:** _____ **Run Start**

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____ **Stop**

Draw Nbr	Revision Nbr
D4132	A

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
100 Waterjet FLOW CNC Waterjet	FLOW WATER JET **Memo** 1-Cut as per Dwg D4132 Dwg Rev: A Prog Rev: A 2-Deburr if necessary	0.00 0.00				[signature]	10	07	14 (4)
110 QC Quality Control	QC2- Inspect parts off machine FAI/FAIB **Memo**	0.00 0.00				[signature]	10	07	14 (4)
120 QC Quality Control	QC8- Inspect parts - second check **Memo**	0.00 0.00				(4)			

10/07/14

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Work Order ID 60303

Thursday, July 01, 2010 1:09:42 PM

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Item Name: Gasket

Start Date: 7/1/2010 **Start Qty:** 4.00 **Cust Item ID:**

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Reference:

Run Start

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: Sylvite	0.00							
Packaging	**Memo**	0.00							
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							
QC	**Memo**	0.00							
Quality Control									

10/7/15 4

10/7/15

MF

10-7-15

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Picklist Print

Thursday, July 01, 2010 1:09:47 PM

Work Order ID: 60303

Parent Item: D4132-3

Parent Item Name: Gasket

Start Date: 7/1/2010 **Required Date:** 7/8/2010

Start Qty: 4.00 **Required Qty:** 4.00

Comments: IPP Rev:A 10.06.24 new issue DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MNEO60S.063		Purchased	No			100	sf	364.8531	1.0446	4.398316			
NEOPRENE SHEET 0.063													

Location	Loc Qty	Loc Code	
MAT	259.6		
114691	259.6		
MAT052	105.2531		
114176	105.2531		

ml 10.07.14

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

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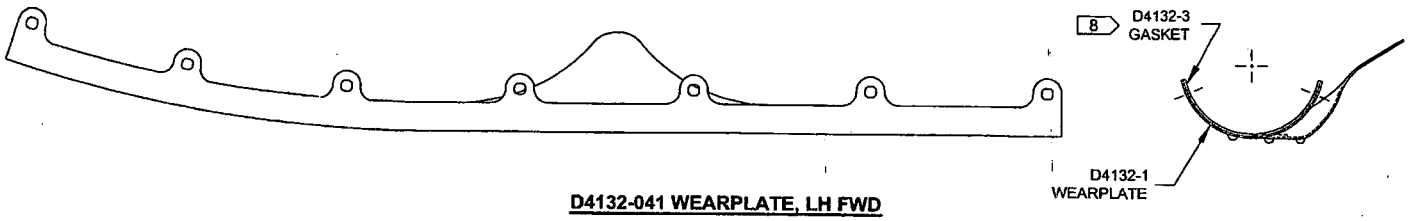
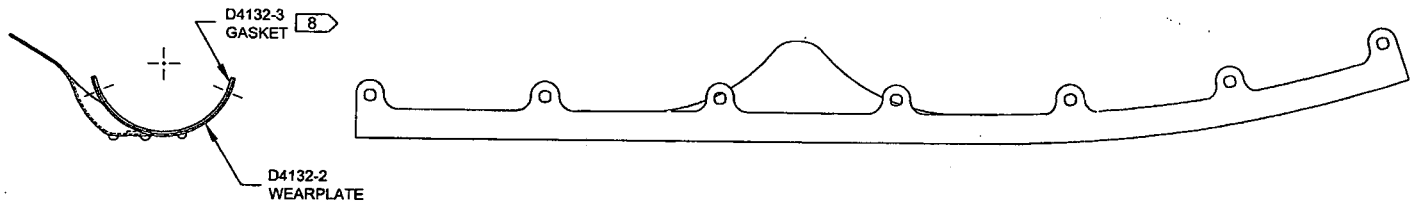
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

QTY -041	QTY -042	PART NUMBER	DESCRIPTION
X		D4132-041	WEARPLATE, LH FWD
	X	D4132-042	WEARPLATE, RH FWD
1		D4132-1	WEARPLATE
	1	D4132-2	WEARPLATE
1	1	D4132-3	GASKET
A/R	A/R	1300 / 1300L	3M SCOTCH-GRIP ADHESIVE



D4132-041 WEARPLATE, LH FWD



D4132-042 WEARPLATE, RH FWD

RELEASED
2010 -06- 29
MP

NOTES:
1) MATERIAL: N/A
2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: N/A
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4132-xxx" USING YELLOW PAINT MARKER ON INSIDE SURFACE
7) WEIGHT: -041/-042 = 2.1 lbs
8) BOND D4132-3 GASKET TO INNER SURFACE OF WEARPLATE USING A THIN LAYER OF 3M 1300/1300L SCOTCH GRIP ADHESIVE

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 60303

REV.	DESCRIPTION	BY	DATE
A	NEW ISSUE	CP	10.06.15

DESIGN	CP	DART AEROSPACE USA, INC PORT HADLOCK, WA
DRAWN	CP	
CHECKED		DRAWING NO. REV. A
MFG. APPR.		D4132 SHEET 1 OF 6
APPROVED		TITLE SCALE
DE APPR.		WEARPLATE, FWD NTS
DATE	10.06.15	

BP 10-7-01

Dart Aerospace Ltd

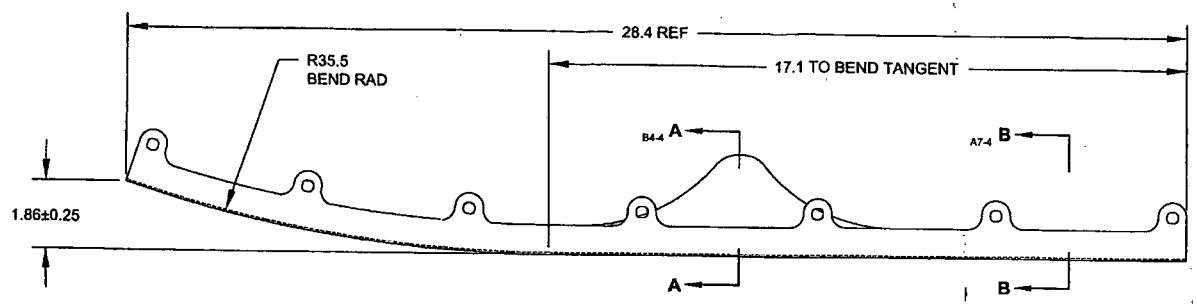
W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

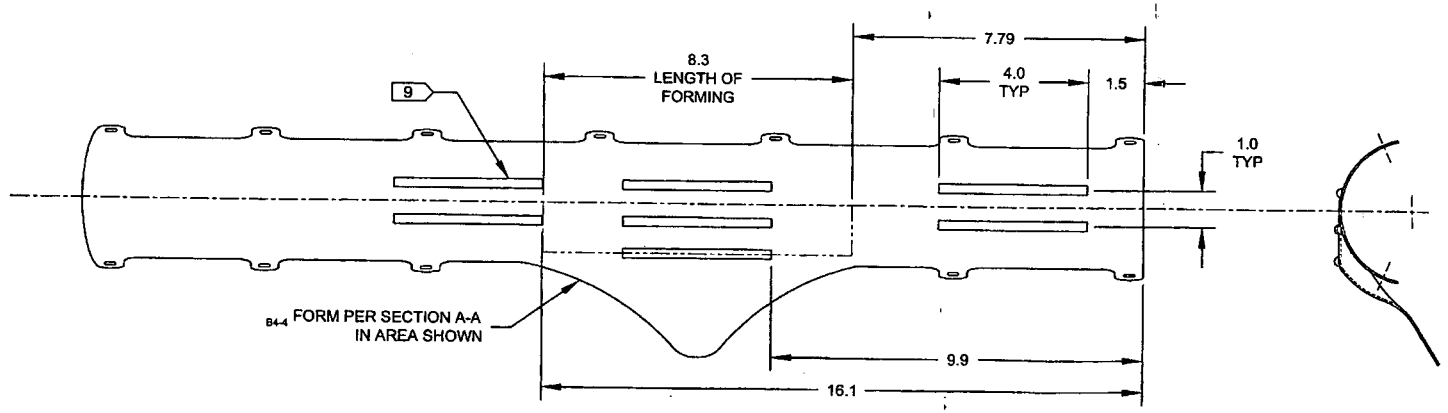
Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries





D4132-1 WEARPLATE, LH

NOTES:

1) MATERIAL: MAKE FROM D4132-1F
2) FINISH: POWDER COAT "GREY SANDTEX" (4.3.5.6) PER DART QSI 005 4.3
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010
6) IDENTIFICATION: NONE
7) WEIGHT: 1.8 lbs
8) WELD PER QSI 004
9) 2059B HARDCOAT WELDS, 0.063 TO 0.125 HIGH

MA0303

RELEASED
2010-06-28

DESIGN		DART AEROSPACE USA, INC
DRAWN		PORT HADLOCK, WA
CHECKED		DRAWING NO. D4132 REV. A
MFG. APPR.		SHEET 2 OF 6
APPROVED		TITLE WEARPLATE, FWD
DE APPR.		SCALE NTS
DATE 10.06.15		

Dart Aerospace Ltd

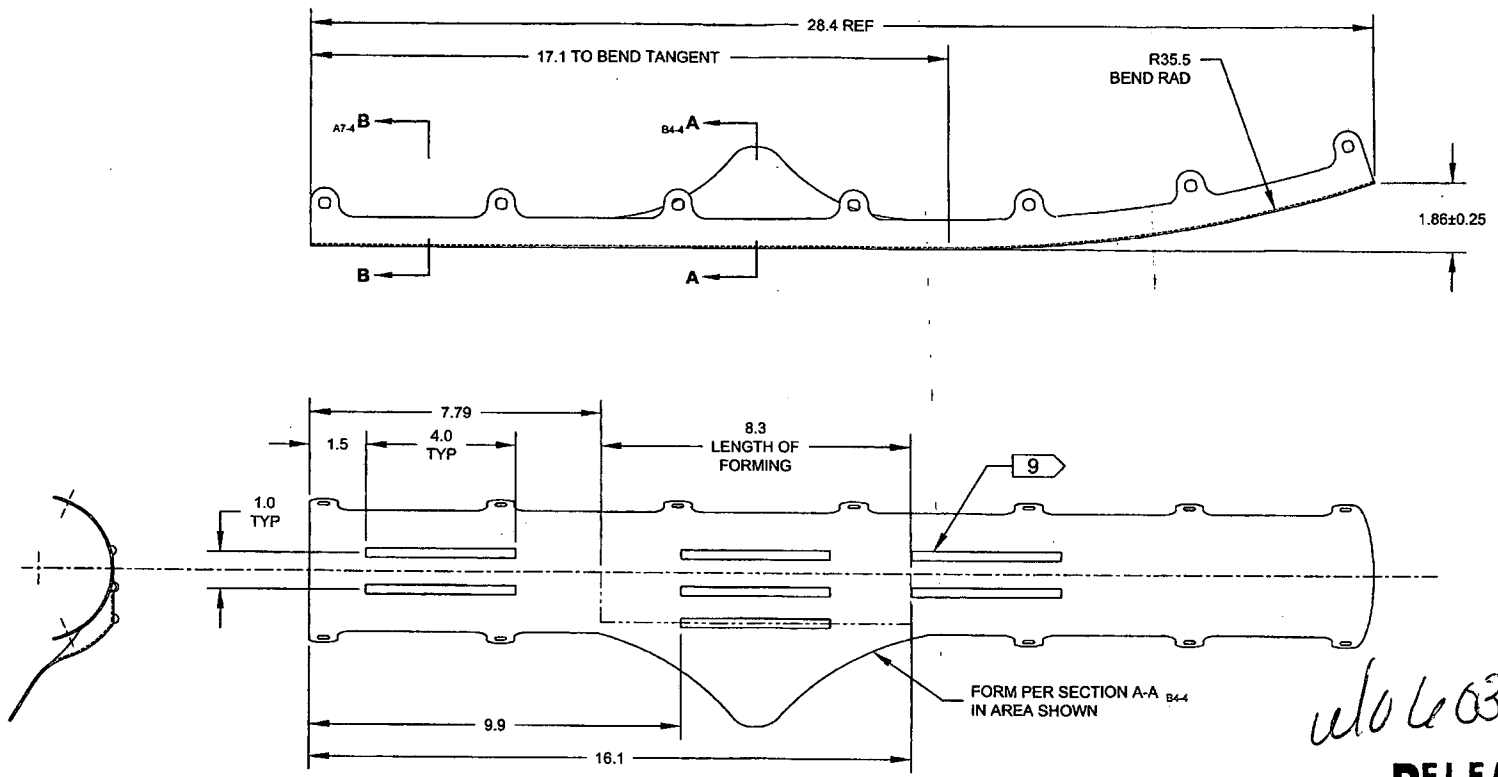
W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries



D4132-2 WEARPLATE, RH

wo 60303

RELEASED
2010 -06- 28

NOTES:
1) MATERIAL: MAKE FROM D4132-1F
2) FINISH: POWDER COAT "GREY SANDTEX" (4.3.5.6) PER DART QSI 005 4.3
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010
6) IDENTIFICATION: NONE
7) WEIGHT: 1.8 lbs
8) WELD PER QSI 004
9) 2059B HARDCOAT WELDS, 0.063 TO 0.125 HIGH

DESIGN		DART AEROSPACE USA, INC
DRAWN		PORT HADLOCK, WA
CHECKED		DRAWING NO. D4132 — REV. A — SHEET 3 OF 6
MFG. APPR.		TITLE WEARPLATE, FWD — SCALE NTS
APPROVED		
DE APPR.		
DATE 10.06.15		

Dart Aerospace Ltd

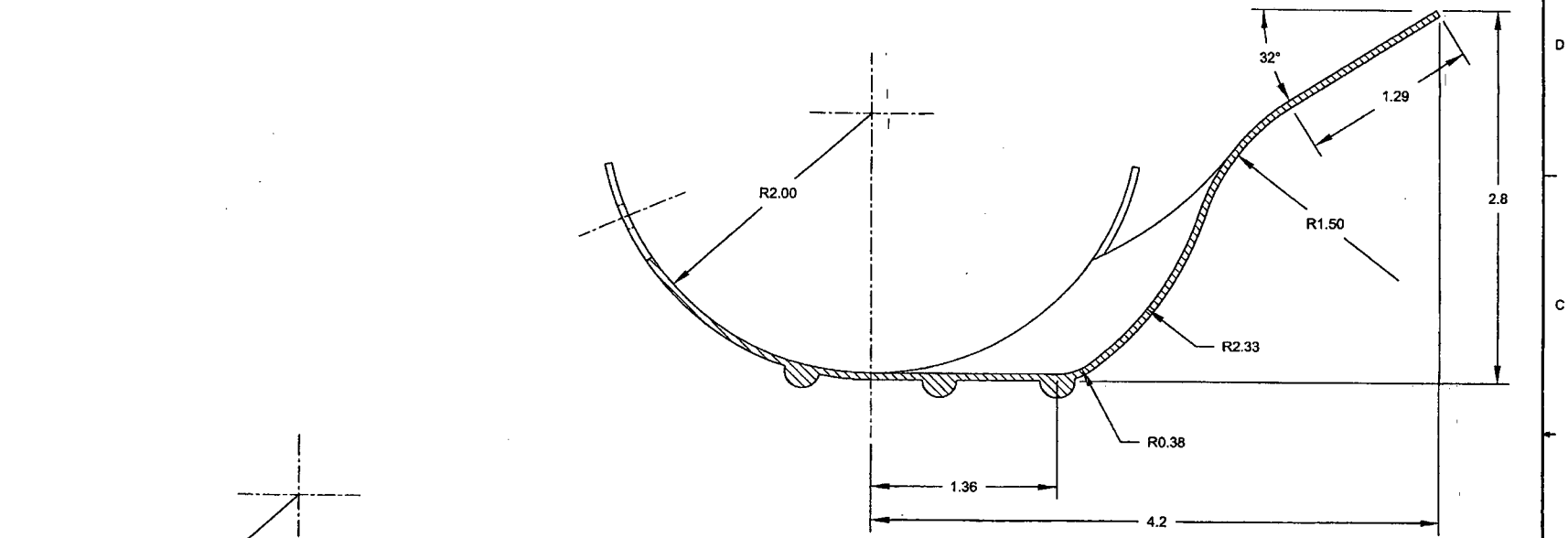
W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

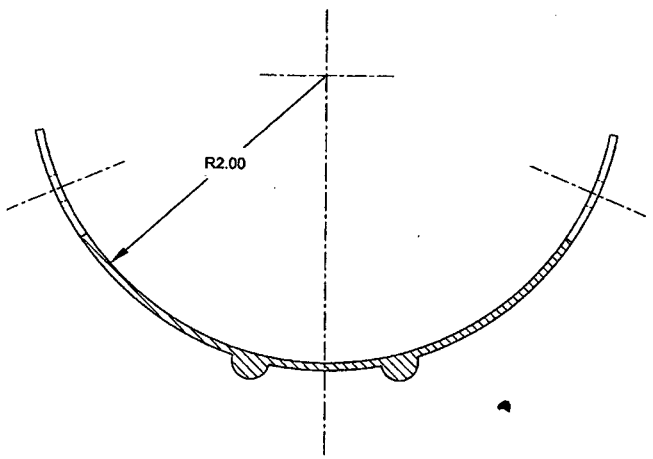
Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries



D5-2, D5-3 **SECTION A-A**
SCALE 4X



D4-2, D6-3 **SECTION B-B**
SCALE 4X

w/o 60303

RELEASED
2010-08-29

DESIGN	qp	DART AEROSPACE USA, INC PORT HADLOCK, WA
DRAWN	qp	
CHECKED		DRAWING NO. D4132 — REV. A
MFG. APPR.		SHEET 4 OF 6
APPROVED		TITLE: WEARPLATE, FWD — SCALE: NTS
DE APPR.		
DATE	10.06.15	

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

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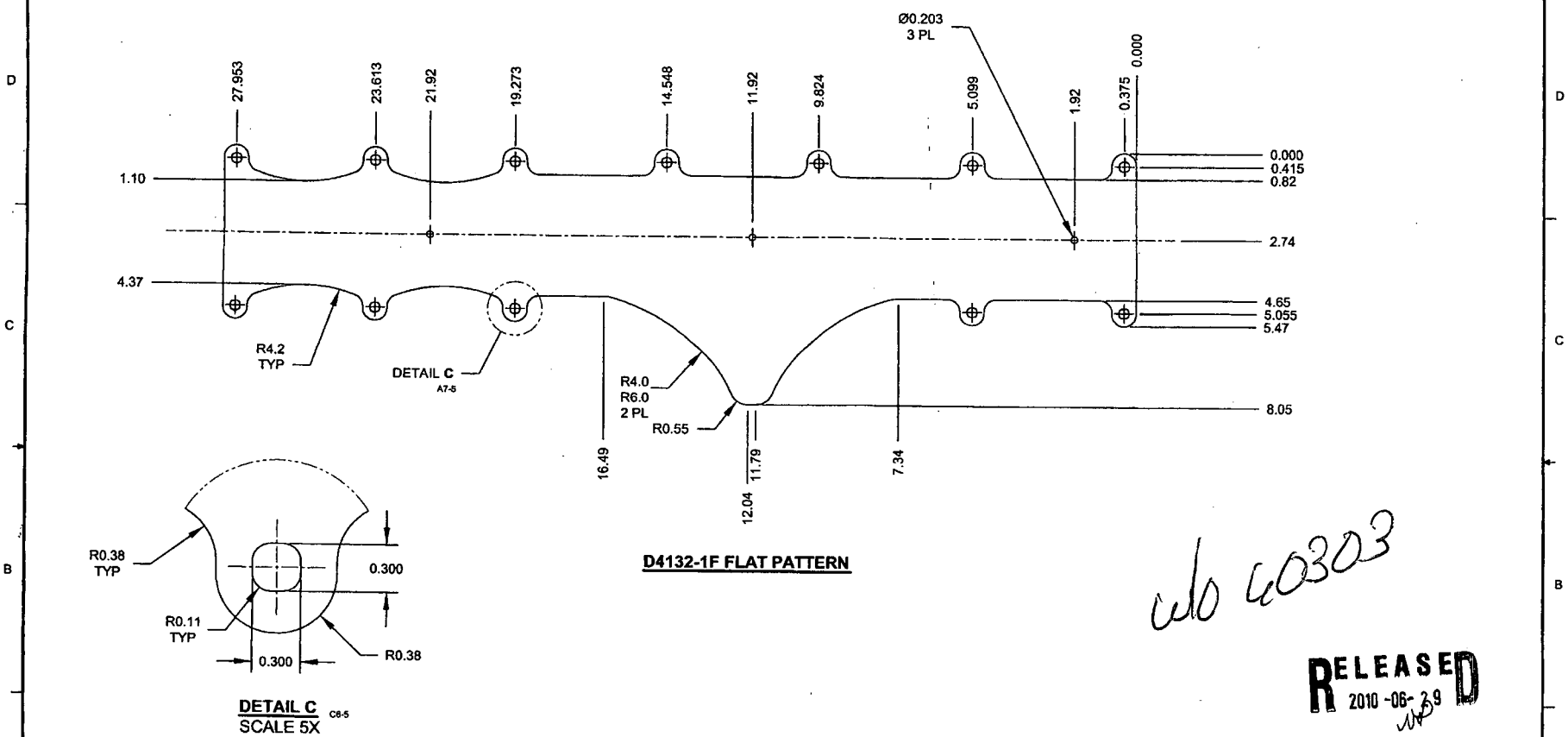
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries



D4132-1F FLAT PATTERN

DETAIL C C8-5
SCALE 5X

wo 60303

RELEASED
2010-06-29

NOTES:
1) MATERIAL: AISI 304/316 STAINLESS STEEL PER AMS 5513 OR AMS 5524 OR ASTM A240, 18 GAUGE (0.050 THICK)
REF DART SPEC M304S18GA
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010
6) IDENTIFICATION: NONE
7) WEIGHT: 1.8 lbs

DESIGN		DART AEROSPACE USA, INC
DRAWN		PORT HADLOCK, WA
CHECKED		DRAWING NO. D4132 — REV. A — SHEET 5 OF 6
MFG. APPR.		TITLE — SCALE
APPROVED		WEARPLATE, FWD — NTS
DE APPR.		
DATE	10.06.15	

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

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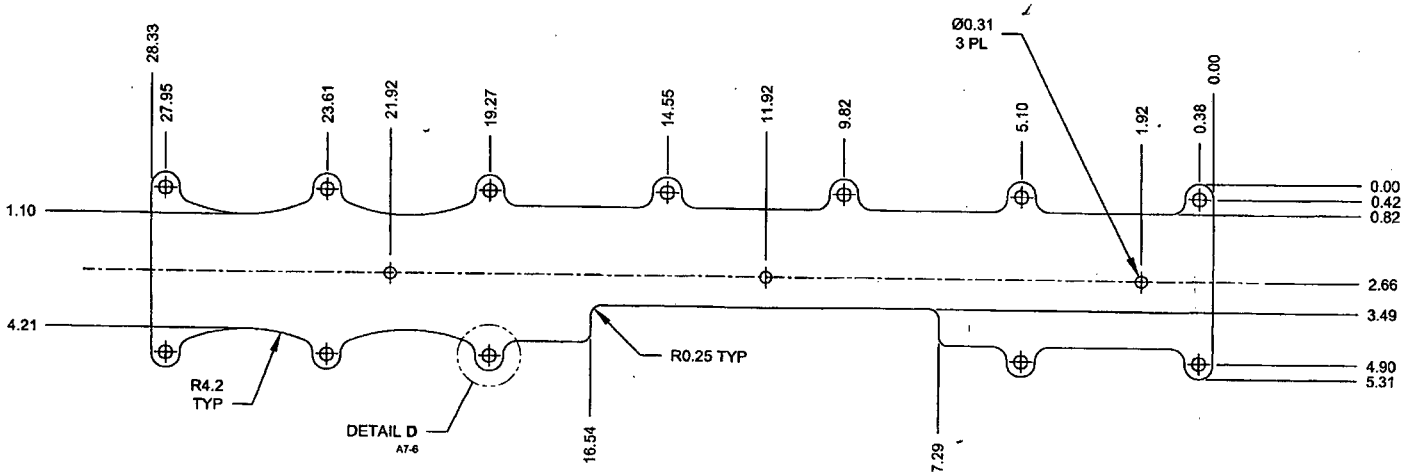
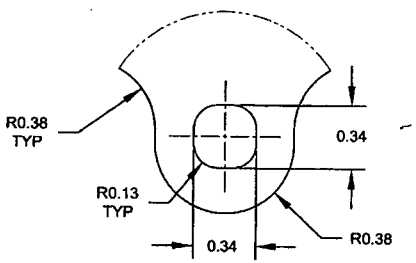


D4132-3 GASKET



DETAIL D C6-6
SCALE 5X

wo 40303

RELEASED
2019-06-29

NOTES:
1) MATERIAL: BLACK NEOPRENE SHEET, 0.063 THICK, 60 DUROMETER
REF DART SPEC M-NEO60-S.063
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: N/A
6) IDENTIFICATION: NONE
7) WEIGHT: 0.36 lbs

DESIGN		DART AEROSPACE USA, INC
DRAWN		PORT HADLOCK, WA
CHECKED		DRAWING NO. D4132 — REV. A
MFG. APPR.		SHEET 6 OF 6
APPROVED		TITLE: WEARPLATE, FWD — SCALE: NTS
DE APPR.		
DATE 10.06.15		

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

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			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	60303
Description: GASKET	Part Number:	D4132-3
Inspection Dwg: D4132 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

[X] First Article [ ] Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
ϕ 0.31	+0.012 -0.001	0.32	✓		VERN	
0.34	+/- 0.030	0.36	✓		VERN	
0.34	+/- 0.030	0.36	✓		VERN	
28.33	+/- 0.030	28.33	✓		M.T	
7.29	+/- 0.030	7.29	✓		M.T	
16.54	+/- 0.030	16.54	✓		M.T	
1.92	+/- 0.030	1.92	✓		M.T	
11.92	+/- 0.030	11.92	✓		M.T	
21.92	+/- 0.030	21.92	✓		M.T	
5.31	+/- 0.030	5.31	✓		M.T	

Measured by:	MM MM
Date:	10-07-14

Audited by:	8
Date:	10/07/14

Prototype Approval:	N/A
Date:	N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	